

Work Order ID 69155

Tuesday, May 03, 2011 1:35:09 PM



Page 1

Item ID:	D4034-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fwd Upper Rib Assembly					
Start Date:	5/3/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	5/17/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	105-3	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4034	B								

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00

Large Fab Memo 0.00

Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564 ✓
2- Weld bushing in rib as per dwg ✓

11-05-05 (32)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00

Quality Control

11-05-05

120 QC5- Inspect part completeness to step on W/O 0.00

QC Memo 0.00

Quality Control

(73)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 5/3/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
	<i>Bucket cell</i>								
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*11-05-05**11/5/05**11-05-6*
(3)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69155

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly




Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1  Rib		Manufactured	No			100	Each	22.0000	1	3		11.05.05	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA006			22						
				67271			22						
D4034-5  Rib		Manufactured	No			100	Each	6.0000	1	3		11.05.05	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			6						
				67270			6						
D2327-3  Spacer Bushing		Manufactured	No			100	Each	7.0000	1	3		11.05.05	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA005			7						
				66535			7						

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, May 03, 2011 1:35:16 PM

Work Order ID: 69155



Parent Item: D4034-043



Parent Item Name: Fwd Upper Rib Assembly

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 3.00

Required Qty: 3.00

D4021-7

Manufactured No

100

Each

10.0000

1

3



Handwritten signature

11.05.05

Hoop

Location

Loc Qty

Loc Code

WA

4

56996

0

67268

4

WA005

6

68090

6

Handwritten circled number 3

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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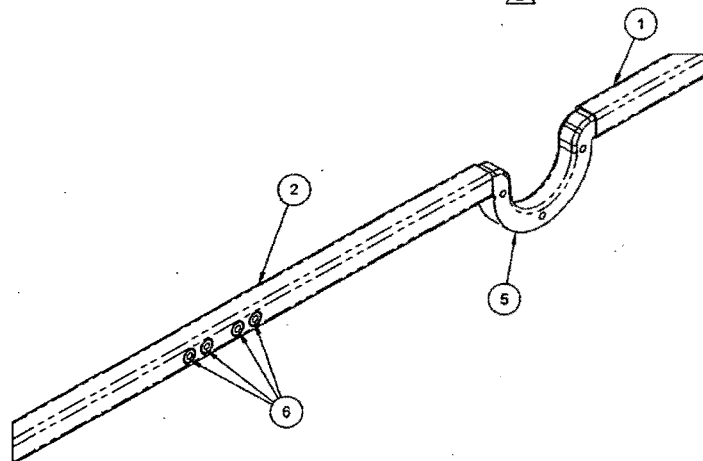
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SHOP COPY
RETURN TO
ENGINEERING

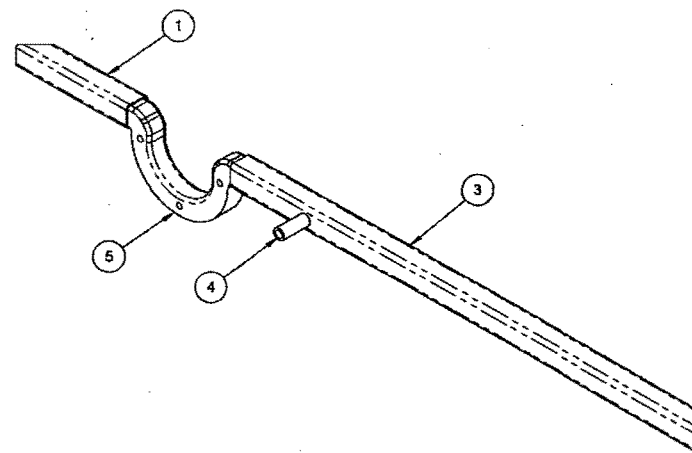
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69155

pl 11-05-8

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
R 2011-01-18
MB

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

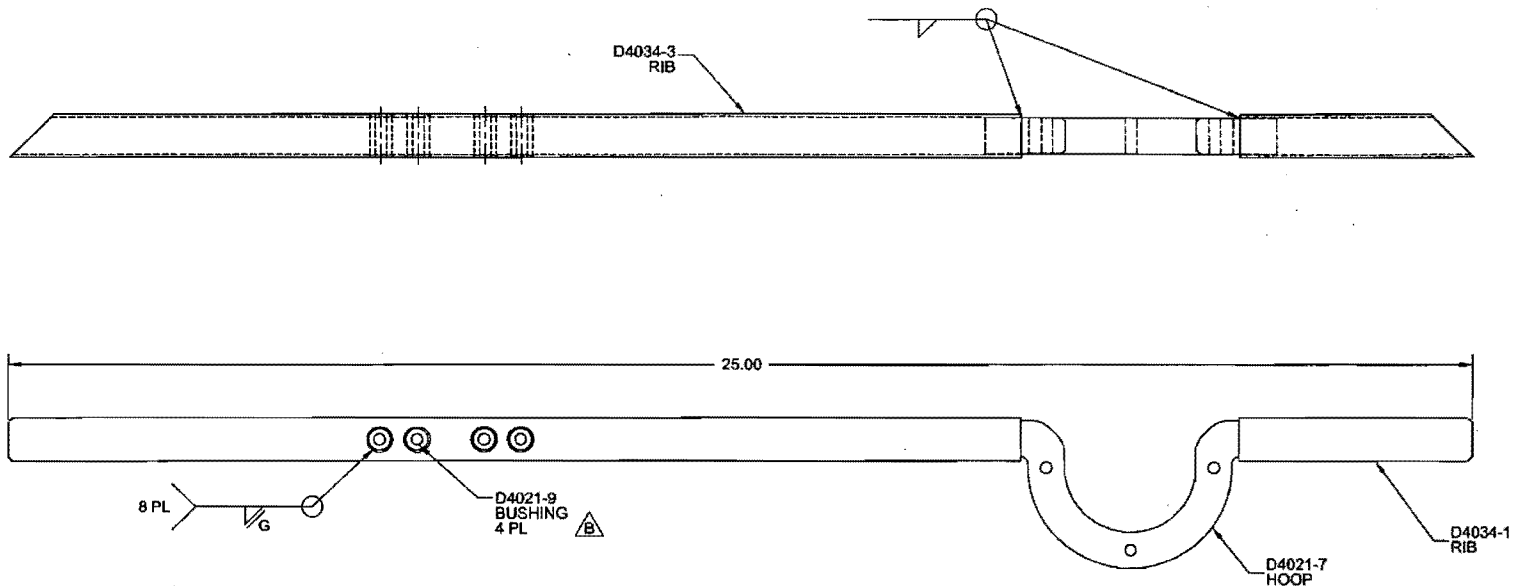
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4034-041 AFT UPPER RIB ASSY

w/b 69155

RELEASED
2011-01-31
NWD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 2 OF 4
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

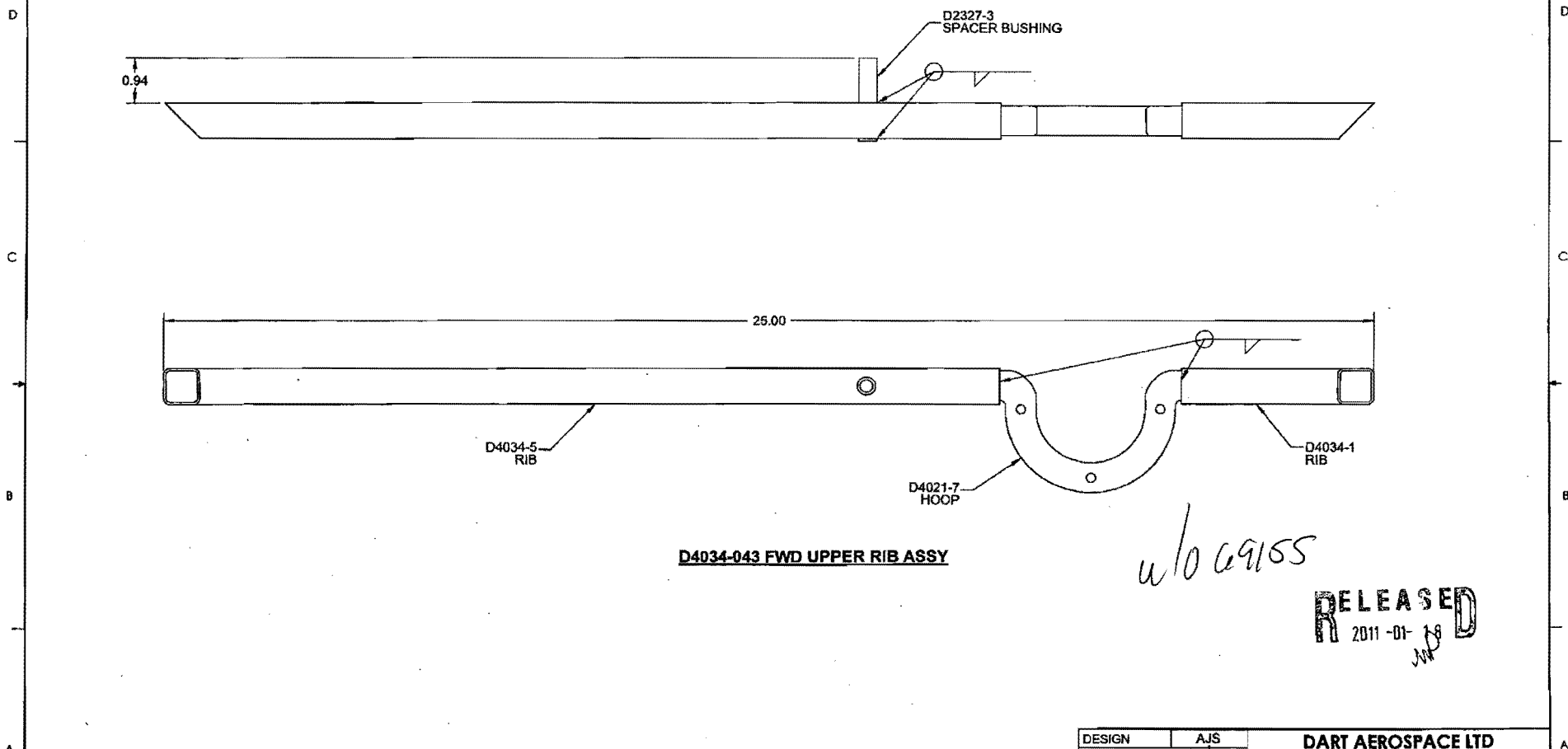
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4034-043 FWD UPPER RIB ASSY

w/0 69155

RELEASED
2011-01-18

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.58 lbs
 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 3 OF 4
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8 7 6 5 4 3 2 1

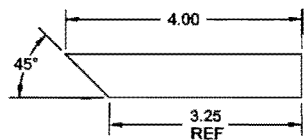
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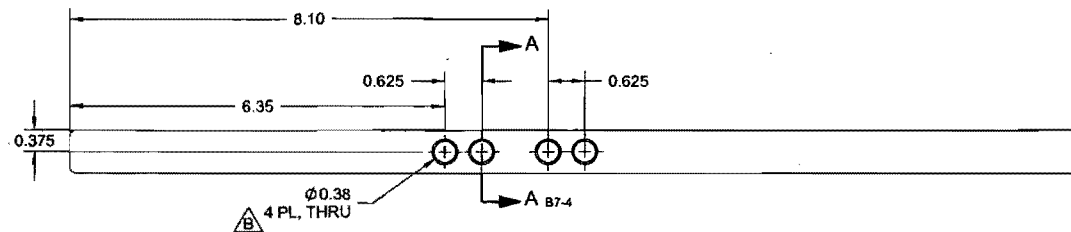


D4034-1 RIB

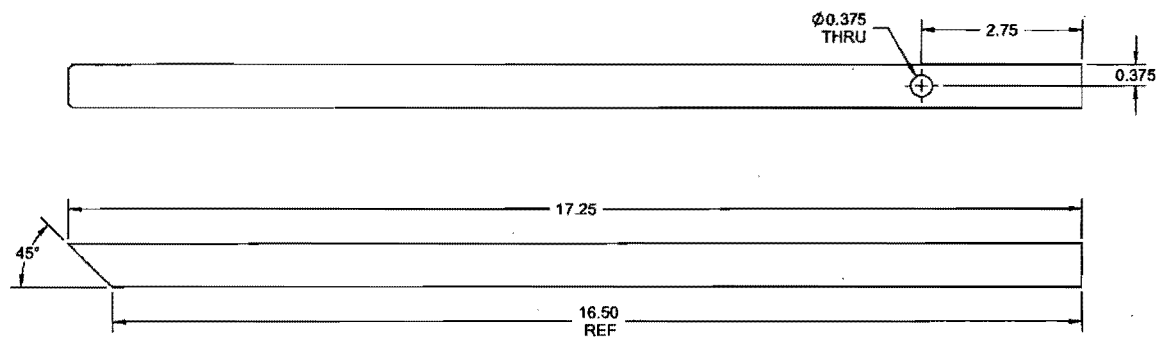
BREAK EDGE
0.030 X 45°
TYP



SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

w/b 69155

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	K	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 4 OF 4
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RELEASED
2011-01-10

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